



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3253-1
Job Sheet 169522



Part No: D3253-1

Job Qty: 6 ea

Part Name: Small Shelf



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/29/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/28/17	0.00	0.00	Start Up Waterjet		OK 17/12/18
100	Waterjet	6 pcs		12/28/17	0.00	0.60	Waterjet1		OK 17/12/18
110	QC	6 pcs		12/28/17	0.00	0.00	QC2 Waterjet-1		OK 17/12/18
120	QC	6 pcs		12/28/17	0.00	0.00	QC8-2		38
130	Brake NC	6 pcs		12/28/17	0.17	0.30	Brake NC 2		SA 3-00
140	QC	6 pcs		12/28/17	0.00	0.00	QC5		PD 18-01-11
150	HandFinish	6 pcs		12/28/17	0.00	0.61	HandFinish1		BE3 18-01-11
160	Powdercoat	6 pcs		12/29/17	0.00	0.27	Powdercoat4		BL 18-01-15
170	QC	6 pcs		12/29/17	0.00	0.00	QC3		BE3 18-01-15
180	Packaging	6 pcs		12/29/17	0.00	0.00	Packaging3-1	51248	BE3 18-01-15
190	QC21-SA	6 Ea		12/29/17	0.00	0.00	QC21		Unit

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 160 - START TIME: 10:15 OVEN TEMPERATURE: 550° FINISH TIME: 1045.

M 1354/8.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	8	261	0	0

Part Specifications

Specifications could not be found.

Plex 12/13/17 11:00 AM dart.poulin.mario

WORK ORDER NON-CONFIRMANCE / UPDATE

CART
AEROSPACE

Work Order update only	

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	
Part No. _____			
NCR No. _____			
Date: _____	Step #: _____	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
Description Work Order Deviation			

Root Cause		Pressure/Forced	
Environment ☐	No Re-verification ☐	☐	Bending ☐
Design ☐	Operator ☐	☐	Centre Not Concentric ☐
Doc/Data ☐	Offset/Setup ☐	☐	Cracks ☐
Equip/Tooling ☐	Supplier ☐	☐	Crimp/Kink/Ripple/Wave ☐
Handling/Pre ☐	Training ☐	☐	Cuffs ☐
Material ☐	Use for Testing ☐	☐	Crushing ☐
Internal Transport ☐	Poor Information ☐	☐	Heat Treat ☐
Tribal Knowledge ☐	Rushing ☐	☐	Wave/Twist in Tube ☐
LOA ☐	Product Improvement ☐	☐	Marks/Chatter ☐
Substation ☐	Process Improvement ☐	☐	
Past Expiry Date ☐	Manufacturing Process ☐	☐	
Misidentified ☐	Past Due ☐	☐	





Small Shelf

PART NO: _____

Revision: _____

Operation: _____

Change No: _____

D3253 - 1

Start up Operation

Mfg Date: 12/18/17

Job No: 169522

QC / QA Coordinator Approval ☐	Lead hand / Supervisor Approval Verification ☐
--	--

Completed By _____	Engineering Quality ☐ Other ☐
---	---

Fit/Function Misaligned/off center ☐	Positioned Wrong Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
--	--

DART AEROSPACE LTD		Work Order:	169522
Description: Small Shelf (Dual Battery Rack)		Part Number:	D3253-1
Inspection Dwg: D3253 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.289	+/-0.010	23.289	1		Vision	
1.425	+/-0.010	1.431	1		Vision	
R0.19	+/-0.030	.19	1		Tap	
0.697	+/-0.010	.696	1			
6.502	+/-0.010	6.503	1			
5.200	+/-0.010	5.202	1			
1.300 Pitch	+/-0.010	1.303	1			
Ø0.098	+0.005/-0.000	Ø.097	1			
0.300	+/-0.010	.304	1			
R0.13	+/-0.030	.13	1			
0.651	+/-0.010	.652	1			
0.643	+/-0.010	.647	1			
8.020	+/-0.010	8.022	1			
7.508	+/-0.010	7.513	1			
R0.13	+/-0.030	.13	1			
0.063	+/-0.005	.064	1			
Grain along 23.289	N/A	1	1			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	17/12/18	Date:	DEC 28 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue P/O D205-579-015	KJ/JLM	<i>[Signature]</i>